

Date: Wednesday, 30/07/2008 5:33:21 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: AFT FACING SEAT ASS'Y RH				
<b>Job Number</b>	: 40827							
<b>Estimate Number</b>	: 13314							
<b>P.O. Number</b>	:			<b>Part Number</b>	: D412769044			
<b>This Issue</b>	: 30/07/2008	S.O. No. :		<b>Drawing Number</b>	: D412-769-2 REV B			
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	: N/A			
<b>First Issue</b>	: / /	Type :		<b>Drawing Revision</b>	: B			
<b>Previous Run</b>	: 40826			<b>Material</b>	:			
<b>Written By</b>	:			<b>Due Date</b>	: 15/08/2008			
<b>Checked &amp; Approved By</b>	<u>JUL 08.8.01</u>			<b>Qty:</b>	1 Um: Each			
<b>Comment</b>	: Est rev A 08.05.12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
2.0	D3782045	Back Leg Assembly	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Back Leg Assembly		
	batch: <u>40873-2</u>		<u>FF 08/09/17</u>
3.0	D3782041	Front Inboard Leg Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Front Inboard Leg Assembly		
	batch: <u>40870-2</u>		<u>No Qty</u>
4.0	D3782044	Front Outboard Leg Assembly, RH	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Front Outboard Leg Assembly, RH		
	batch: <u>40872-2</u>		<u>FF 08/09/17</u>
5.0	D3783041	Lateral Brace Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Lateral Brace Assembly		
	batch: <u>40874</u>		<u>AS 08/09/18</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:33:21 PM  
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## **Process Sheet**

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** AFT FACING SEAT ASS'Y RH

**Job Number:** 40827

**Part Number:** D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	D3783043	Longitudinal Brace Assembly 
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Longitudinal Brace Assembly batch: 40875	AS 08/09/08 (E)
7.0	D3783045	Angle Brace Assembly 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Angle Brace Assembly batch: 40876	No Axis FF 08/09/17
8.0	D3784041	Seat Support Assembly, Center 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, Center batch: 40877	AS 08/09/08 (E)
9.0	D3784043	Seat Support Assembly, LH 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, LH batch: 40878	AS 08/09/08 (E)
10.0	D3784044	Seat Support Assembly, RH 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, RH batch: 40879	AS 08/09/08 (E)
11.0	D37662	Front Rail, RH 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Rail batch: 40864	AC 08/09/08 (E)
12.0	D37663	Rear Rail 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rear Rail batch: 1B40865	AS 08/09/08 (E)

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W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	D37671	Upper Rail 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) -18 Upper Rail batch: B40866 <span style="float: right;">AS 08/09/08</span>
14.0	D37921	Seat Belt Eye Bolt 
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) -2 Seat Belt Eye Bolt batch: B41521x1 B41878 x2 <span style="float: right;">AS 08/09/08</span>
15.0	AN415A	Bolt 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt batch: M168077 <span style="float: right;">AS 08/09/08</span>
16.0	AN45 13A	EYE BOLT 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) EYE BOLT batch: M167938 <span style="float: right;">AS 08/09/08</span>
17.0	AN510A	Bolt 
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: M168471 <span style="float: right;">AS 08/09/08</span>
18.0	AN513A	Bolt 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt batch: M168167 <span style="float: right;">AS 08/09/08</span>
19.0	AN960JD10	Washer 
		Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s) Washer batch: M169059 (or NAS1149D0363J) batch: <span style="float: right;">AS 08/09/08</span>

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD416	Washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Washer batch: _____ (or NAS1149D0463J) batch: M168(ce)	AS 08/09/08 (X)
21.0	AN960JD516	Washer
	Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s) Washer batch: _____ (or NAS1149D0568J) batch: M16867J	AS 08/09/08 (X)
22.0	AN52510R24	Screw
	Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s) Screw batch: _____ M168270	AS 08/09/08 (X)
23.0	MS21042L3	Nut
	Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s) Nut batch: _____ M1687G1	AS 08/09/08 (X)
24.0	MS21042L4	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut batch: _____ M1674G9	AS 08/09/08 (X)
25.0	MS21042L5	Nut
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Nut batch: _____ M168161	AS 08/09/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 08/09/17 (1)

27.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/17 (1R1)

28.0 POWDER COATING POWDER COATING



M1064472

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11:00 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:30 AM

11 08-09-17

(X)

29.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 08/09/17

(X)

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751 Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch: 40869

SS 08/09/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

32.0 D37741 Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B41084

AS 08/09/08 (1)

33.0 D37743 Seat Back, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: 41085

AS 08/09/08 (1)

34.0 AN525 10R22 Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

batch: M107936

AS 08/09/08 (1)

35.0 AN960JD10L Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

batch: M105793

(or NAS1149D0332J) batch: \_\_\_\_\_

AS 08/09/08 (1)

36.0 MS21042L3 Nut



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Nut

batch: M108701

AS 08/09/08 (1)

37.0 AN35A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100188

AS 08/09/08 (1)

38.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-2

FF 08-09-17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40827

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
39.0	QC5	INSPECT WORK TO CURRENT STEP
		S 68/09/17 ⑧
Comment:	INSPECT WORK TO CURRENT STEP	
40.0	PACKAGING 1	PACKAGING RESOURCE #1
		AS 08/09/18 ⑧
Comment:	PACKAGING RESOURCE #1	
Identify and Stock		
Location:	PPO 40827	
41.0	QC21	FINAL INSPECTION/W/O RELEASE
		08/09/18 ⑧
Comment:	FINAL INSPECTION/W/O RELEASE	

Job Completion



MF 08-09-18

**Dart Aerospace Ltd**

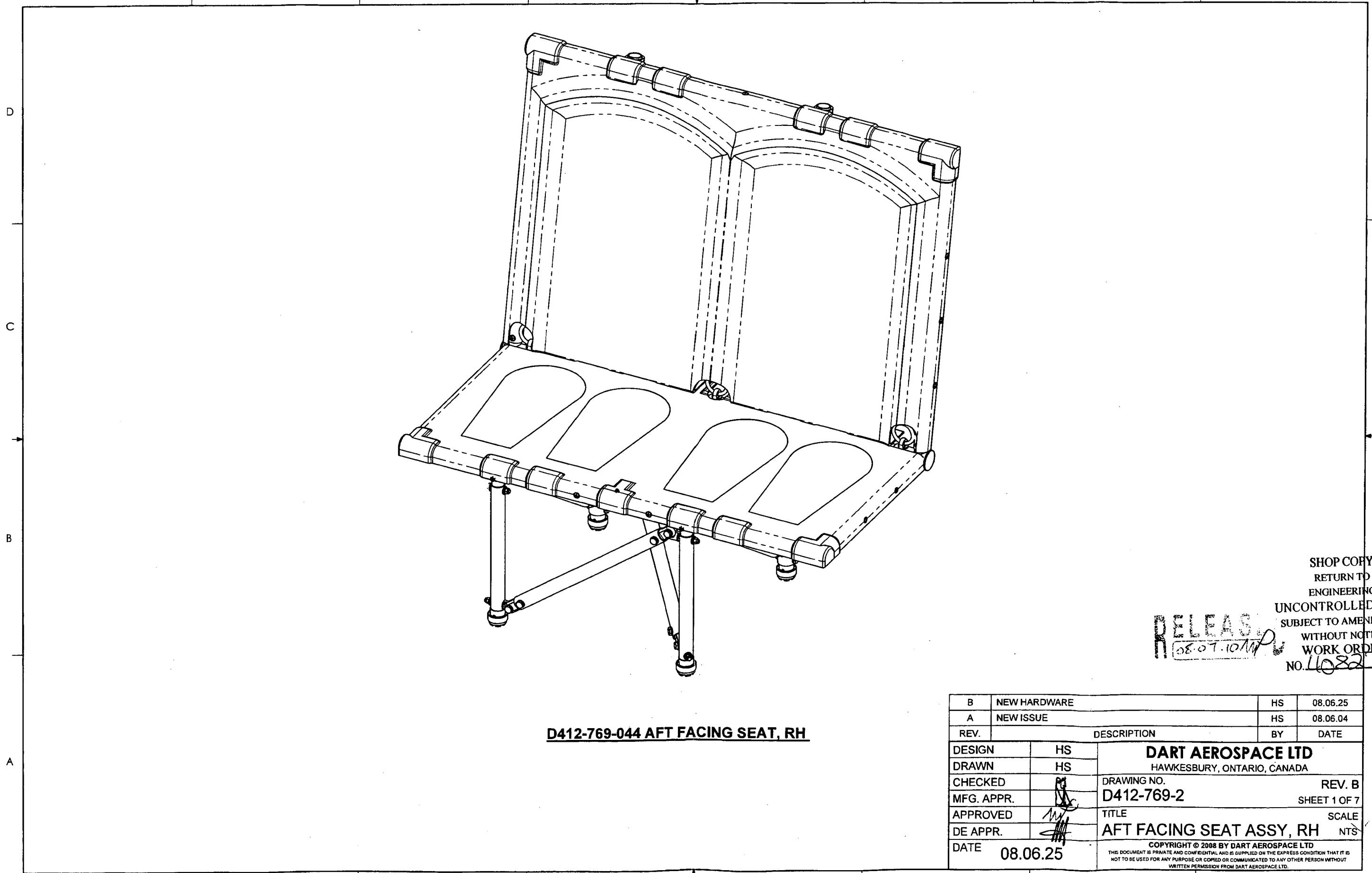
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

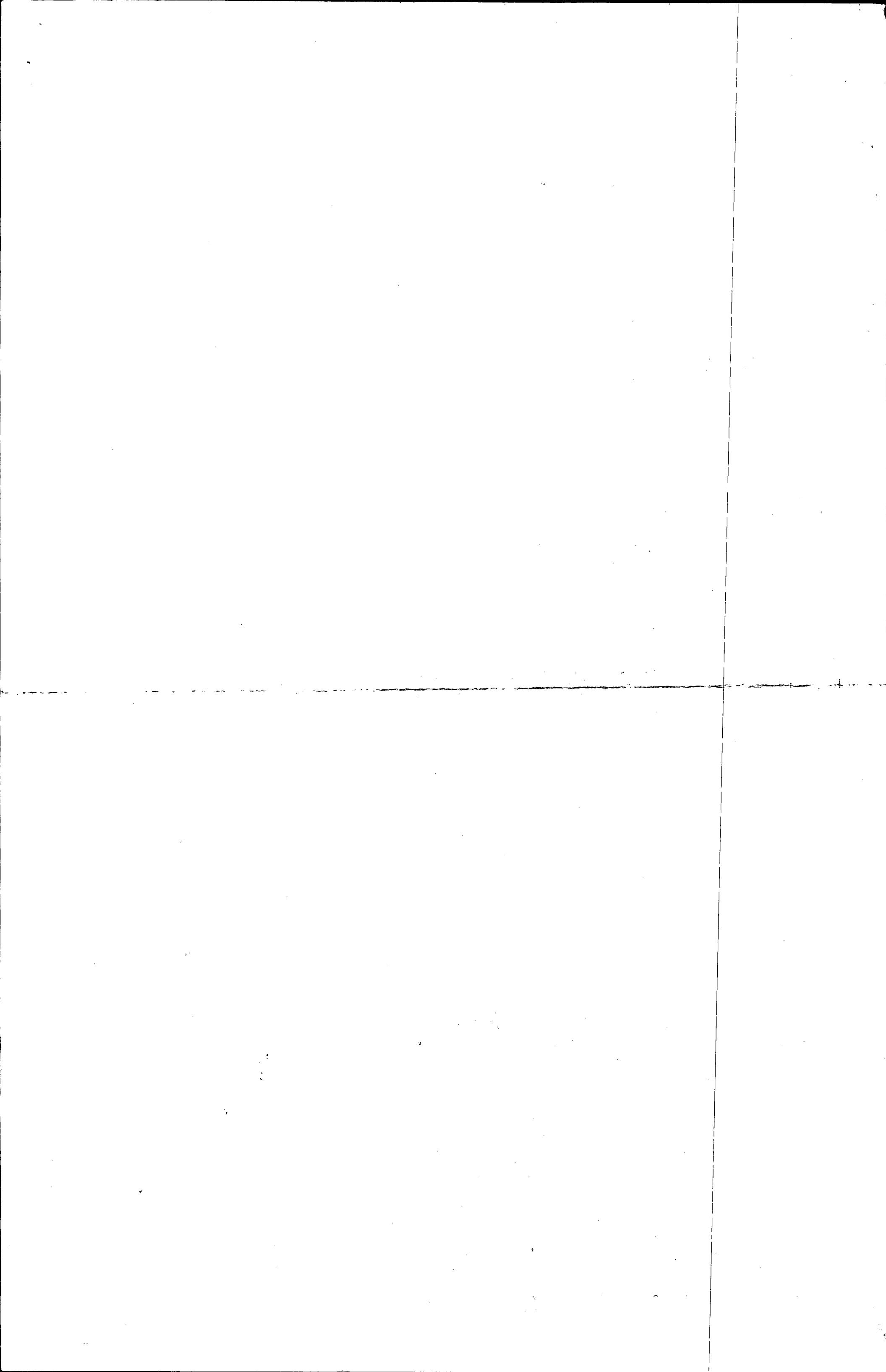
8 7 6 5 4 3 2 1



D412-769-044 AFT FACING SEAT, RH

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		REV. B
CHECKED	P1		SHEET 1 OF 7
MFG. APPR.	AC		
APPROVED	MM		
DE APPR.	MM		
DATE	08.06.25	SCALE AFT FACING SEAT ASSY, RH NTS	

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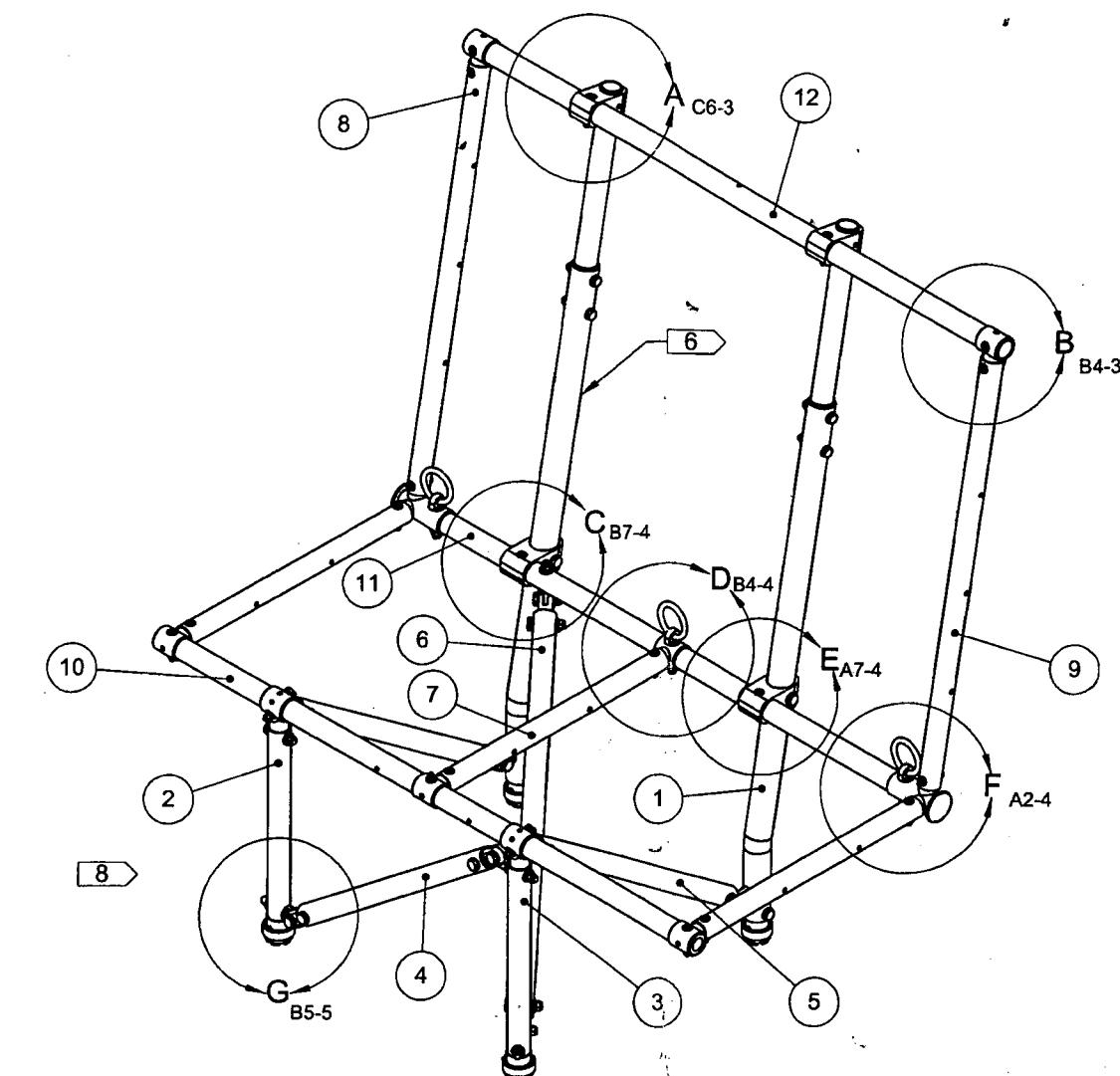
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

**D412-769-044 AFT FACING SEAT, RH**

RELEASED  
08.07.10  
M  
NO. 40927

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

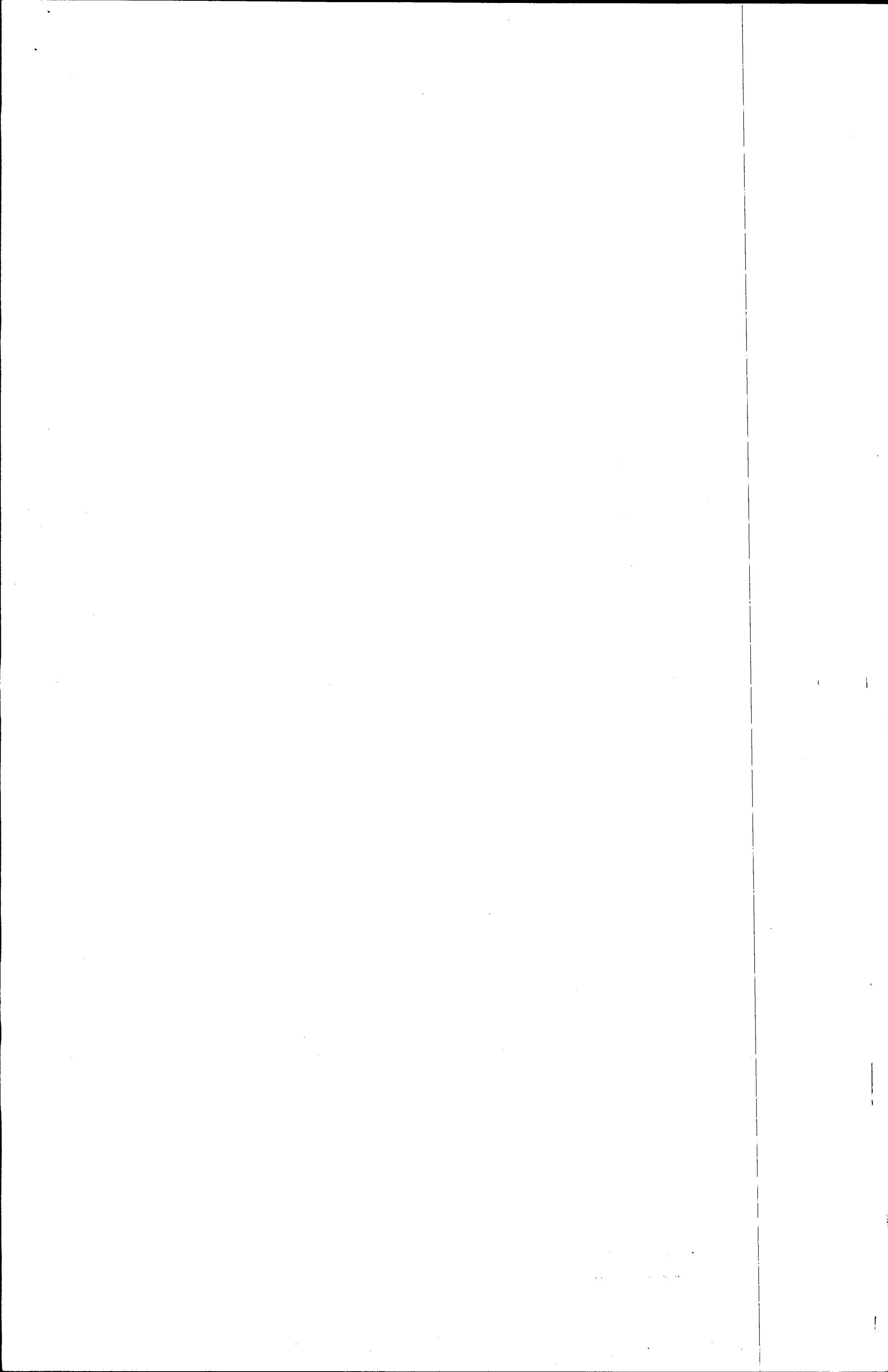
WORK ORDER

NO. 40927

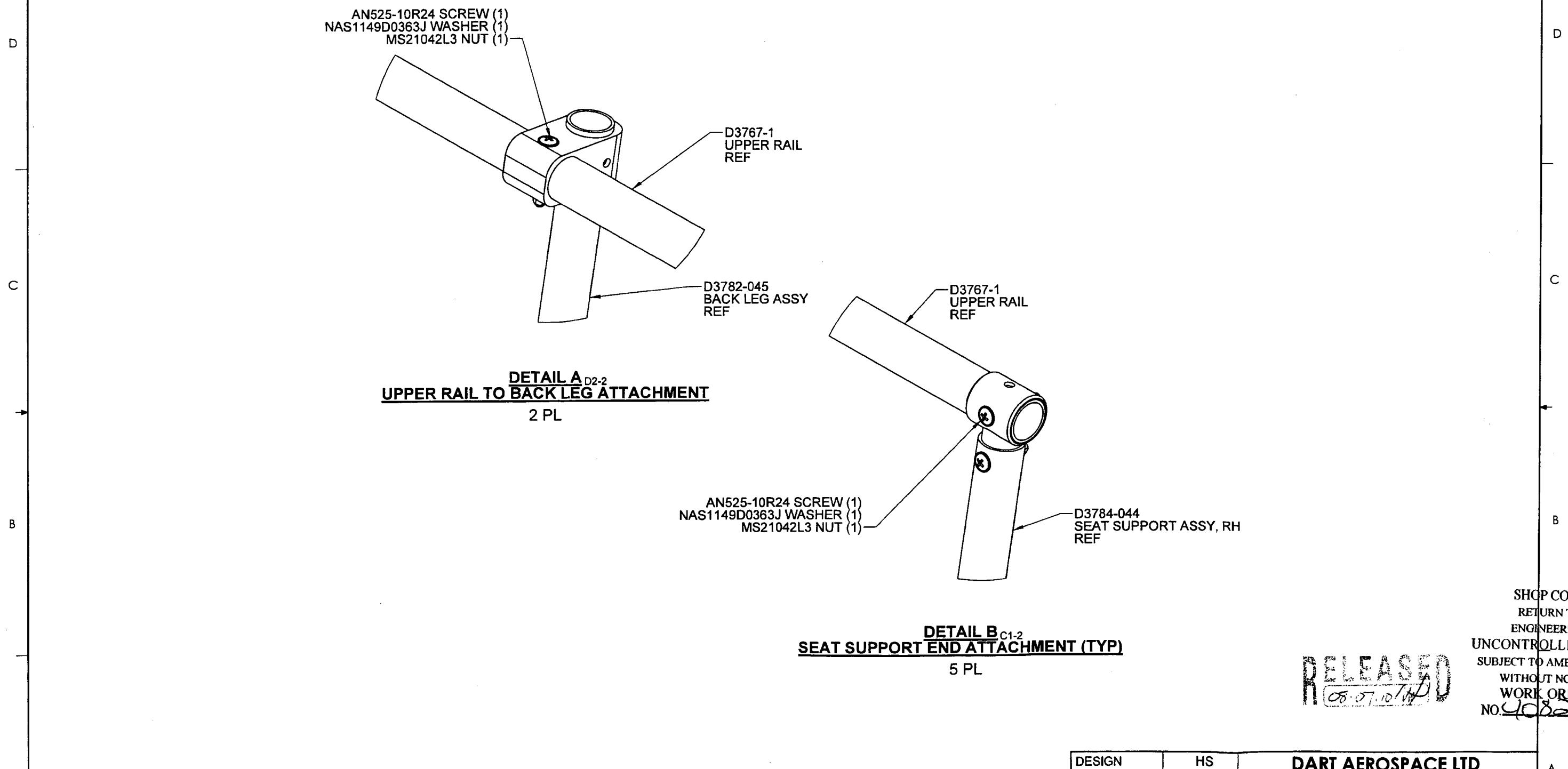
## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	D412-769-2
MFG. APPR.	<i>[Signature]</i>	REV. B	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	AFT FACING SEAT ASSY, RH
DE APPR.	<i>[Signature]</i>	SCALE	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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06-07-10 THP

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WORK ORDER

NO. 40827

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PS	DRAWING NO.	
MFG. APPR.	MM	D412-769-2	REV. B
APPROVED	MM	SHEET 3 OF 7	SCALE
DE APPR.	MM	TITLE	NTS
DATE	08.06.25	AFT FACING SEAT ASSY, RH	

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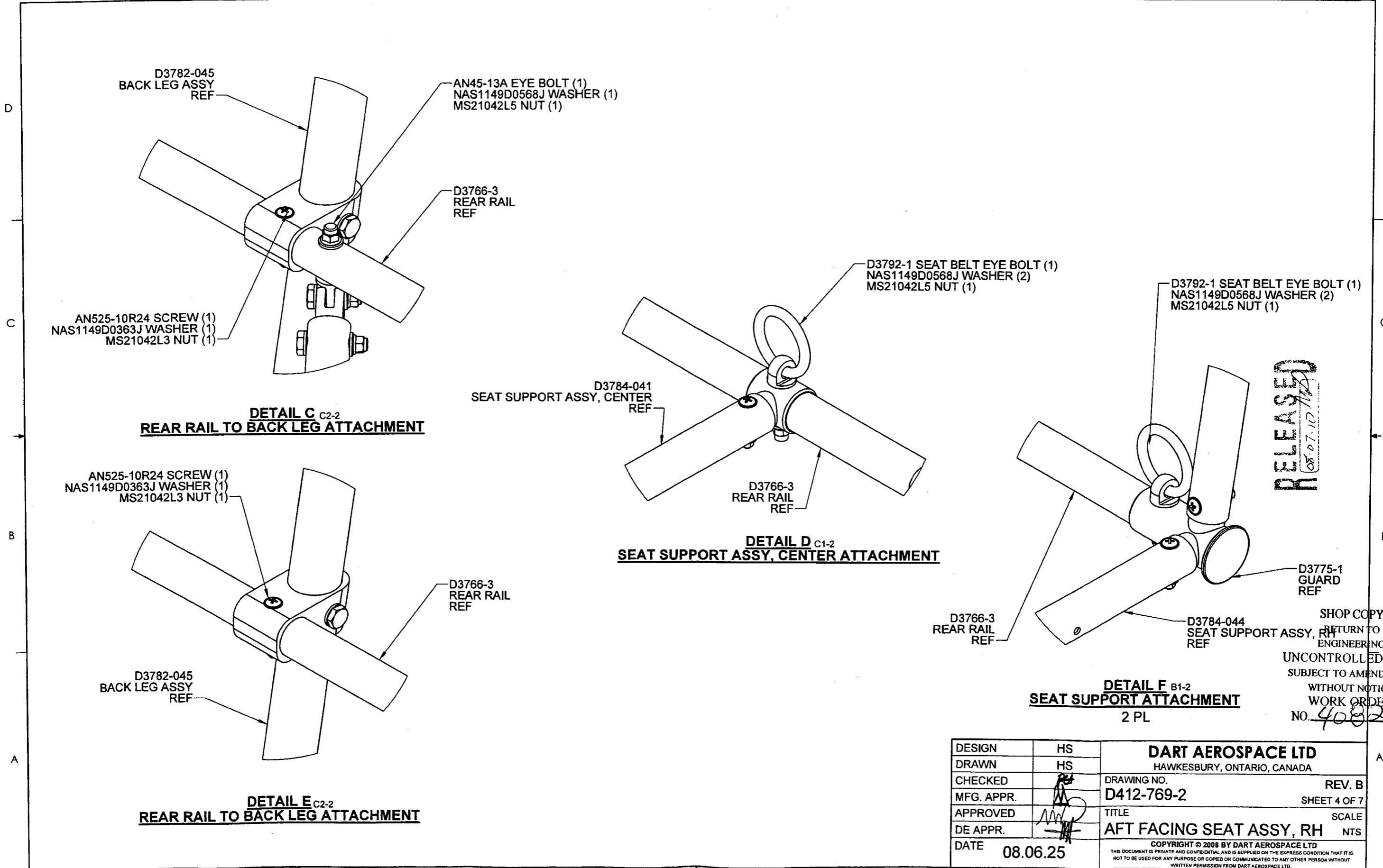
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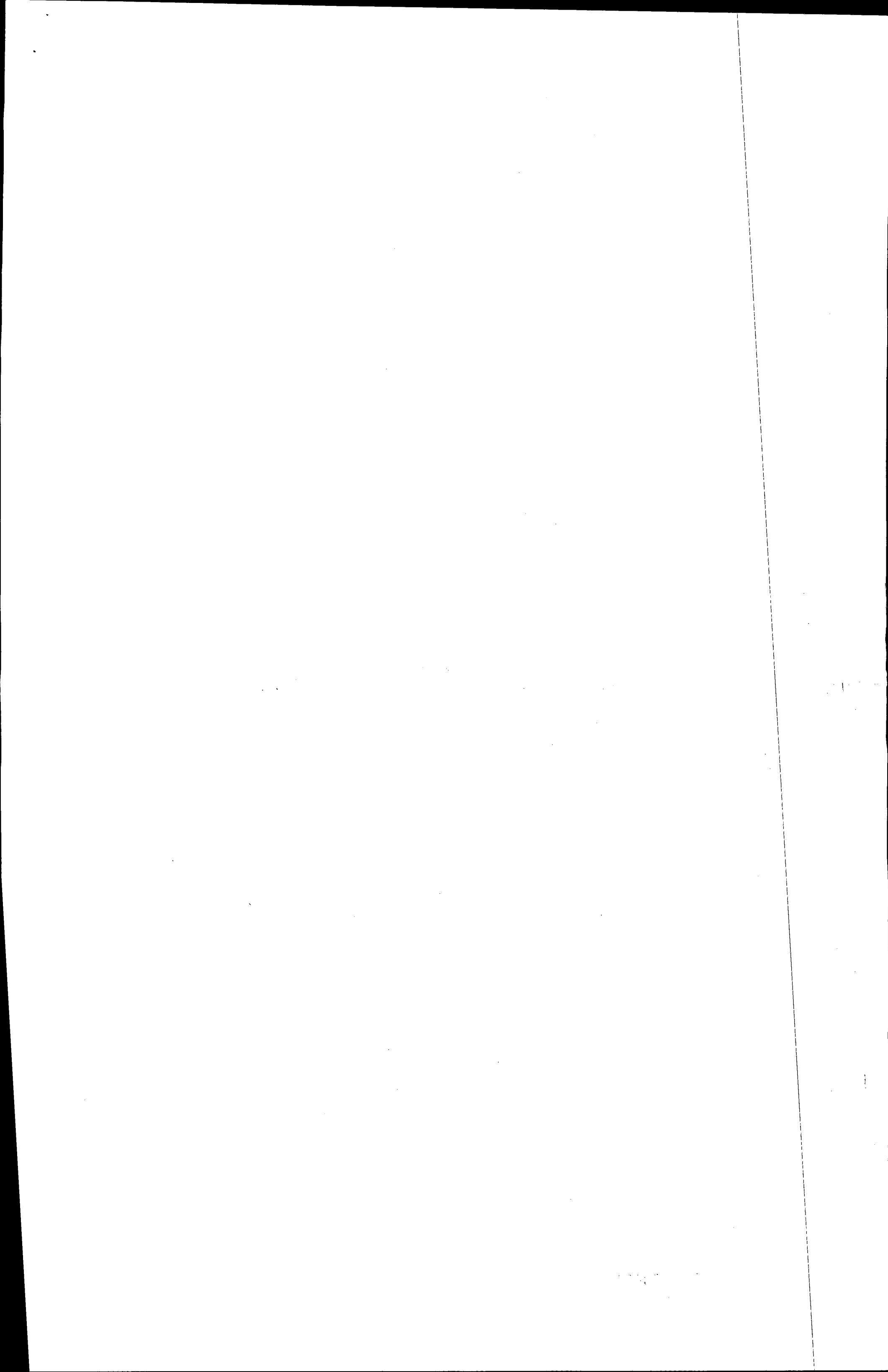
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8 7 6 5 4 3 2 1

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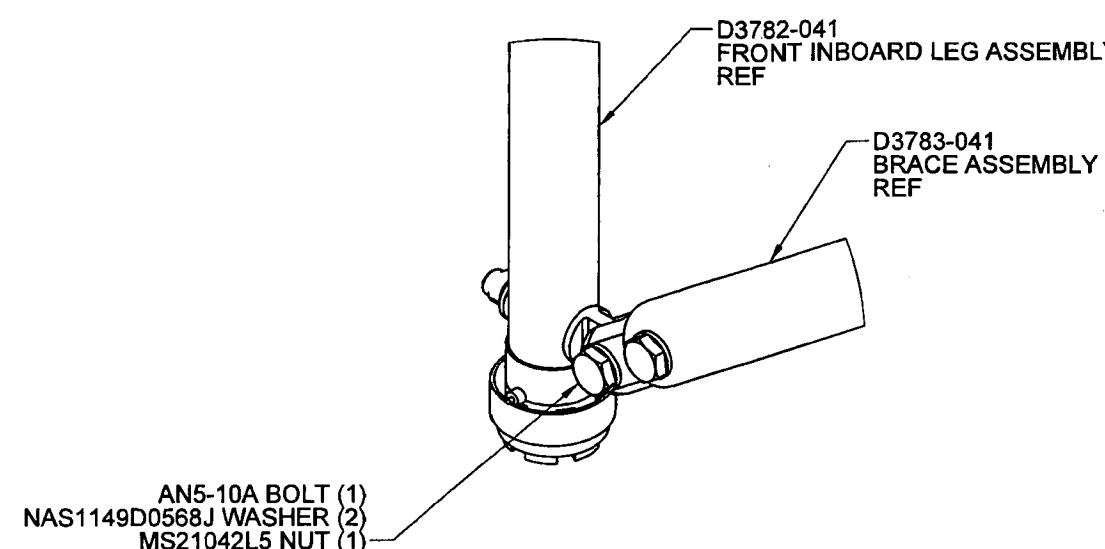
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**DETAIL G<sub>B3-2</sub>**  
**BRACE ATTACHMENT**

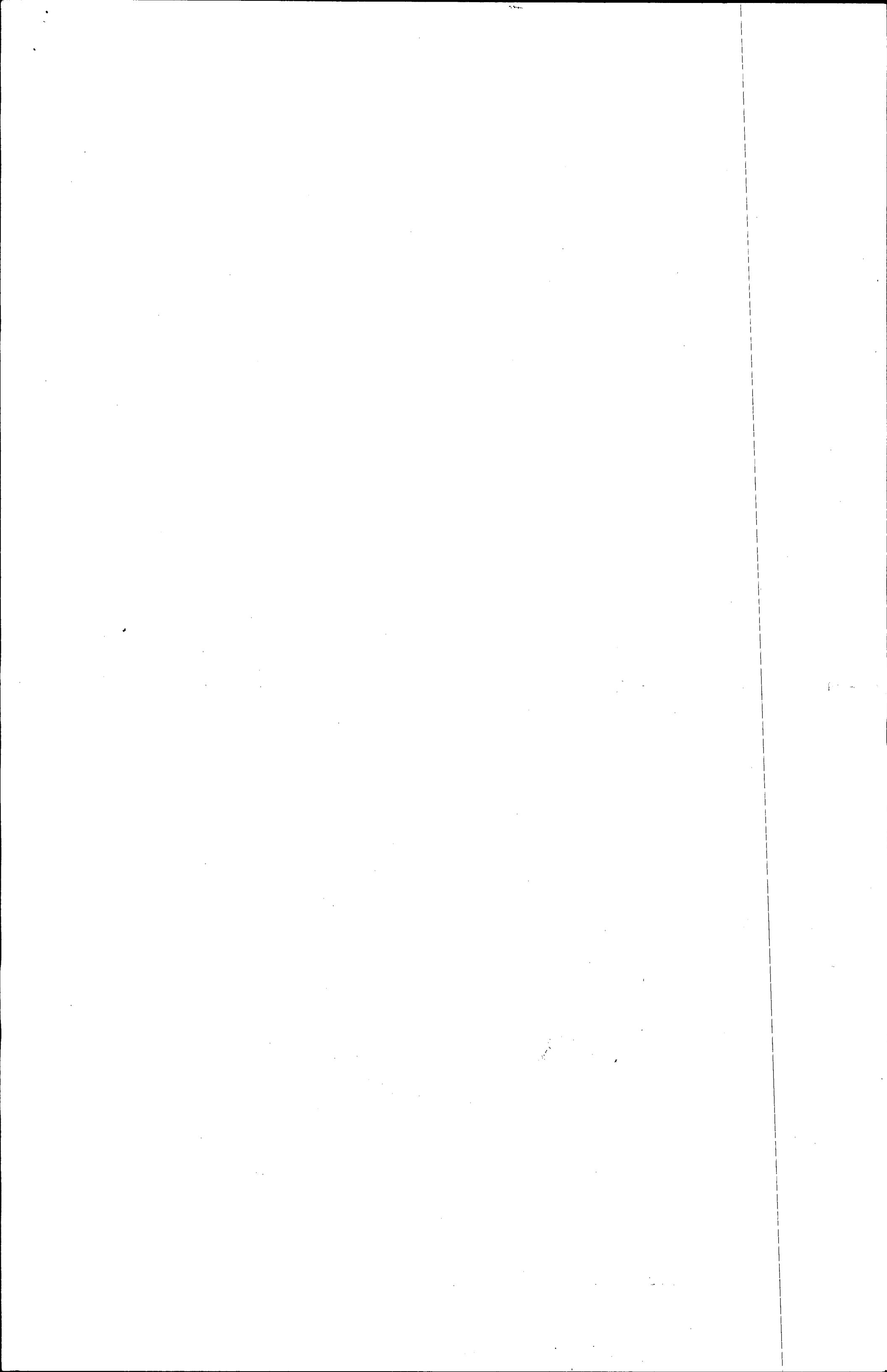
6 PL

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WORK ORDER  
NO. 40827

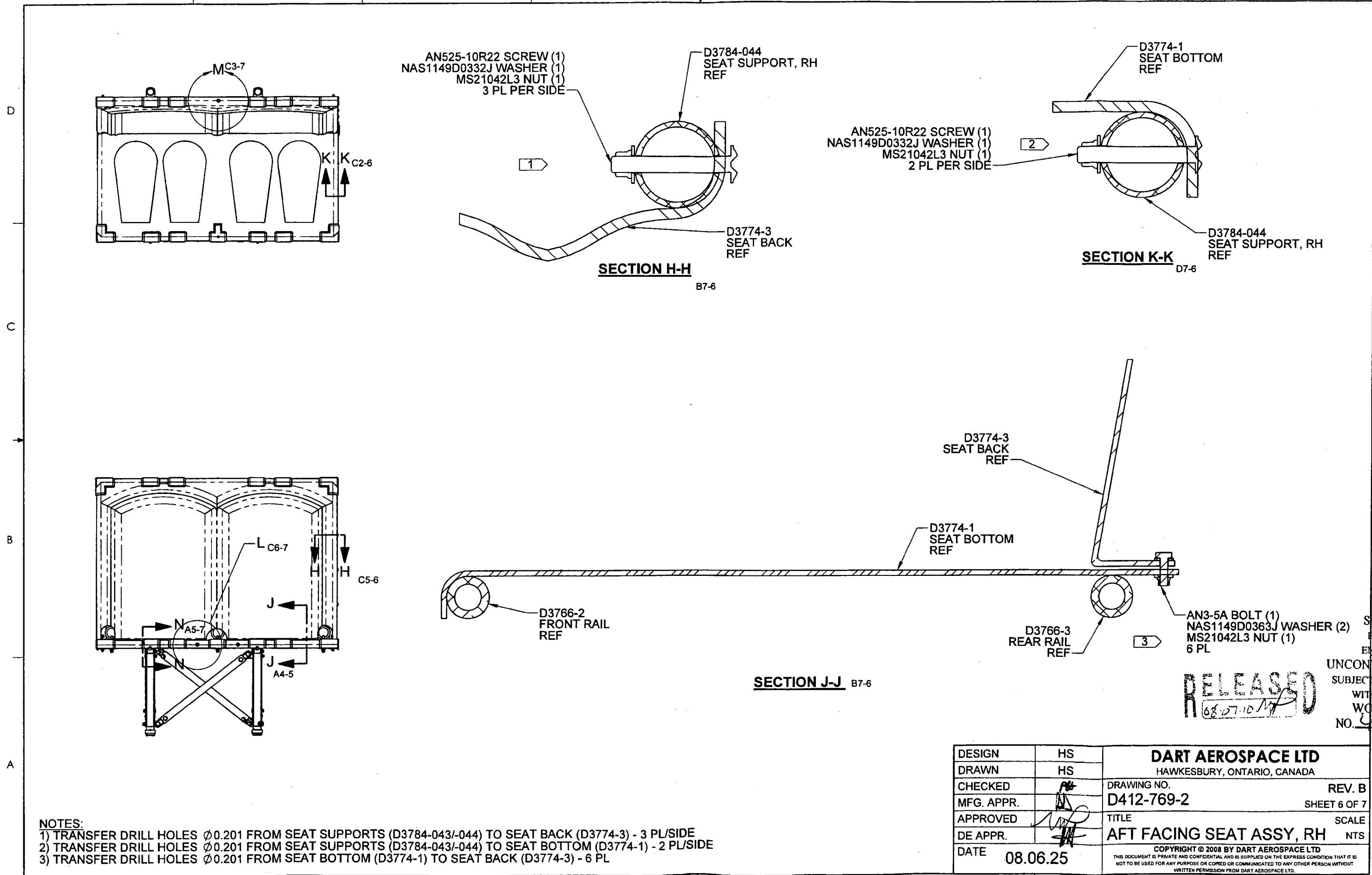
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	
MFG. APPR.	MM	D412-769-2	REV. B
APPROVED	SMP	TITLE	
DE APPR.	MM	SCALE	
DATE	08.06.25	AFT FACING SEAT ASSY, RH	

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8 7 6 5 4 3 2 1



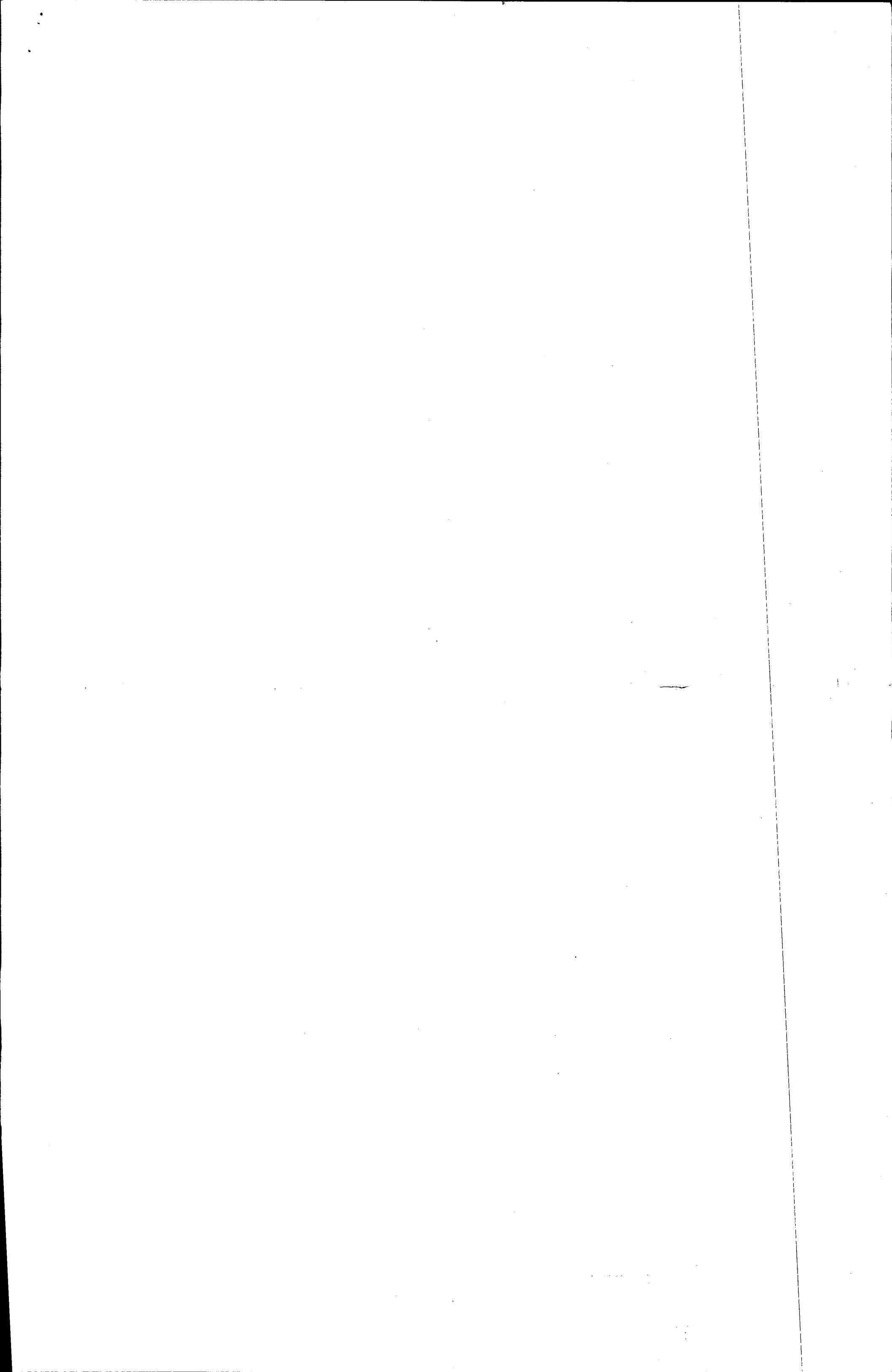
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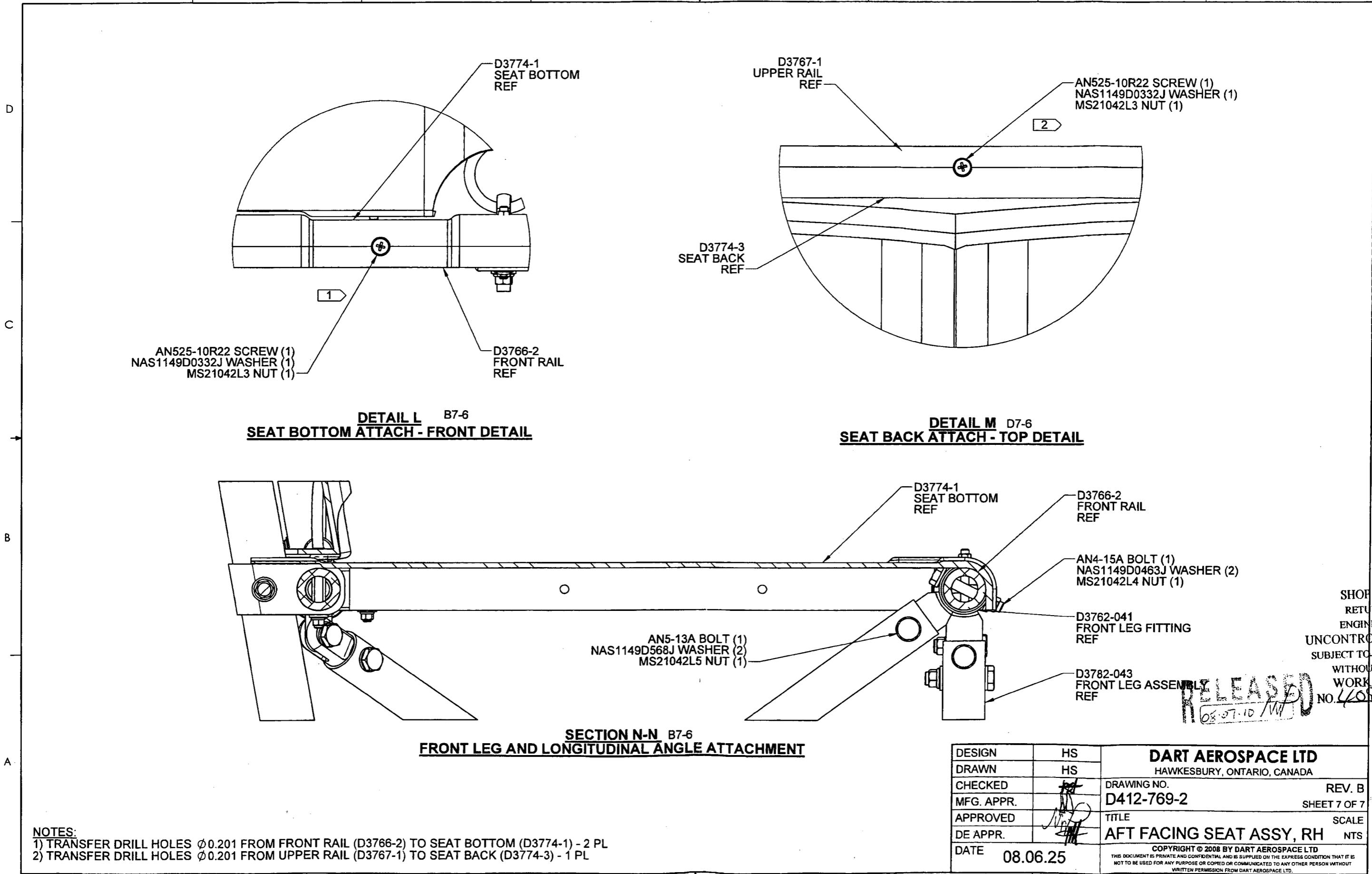
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